

Work Order ID 56666

March 4, 2010 10:08:16 AM



Page 1

Item ID: D3780-041

Accept



Setup Start



Revision ID:

Item Name: Armrest Assembly

Stop



Start Date: 3/04/10

Start Qty: 400



Cust Item ID:

Required Date: 3/08/10

Req'd Qty: 400



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3780

Rev D

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- assemble as per dwg D3780

****torque screws as per dwg D3780****

6/3/10/03/11 (2)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

was waiting for certs for 03261-043

Memo

0.00

Quality Control

8/10/03/17

(2)

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

261

Rec'd 3/17 (2)

Work Order ID 56666

March 4, 2010 10:08:16 AM



Page 2

Item ID: D3780-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Armrest Assembly

Start Date: 3/04/10

Start Qty: 4.00



Cust Item ID:

Required Date: 3/08/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/17
MF
10-3-17

Picklist Print

March 4, 2010 10:08:13 AM

Page 1

Work Order ID: 56666

Parent Item: D3780-041

Parent Item Name: Armrest Assembly

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
IPP Rev:B 08-07-22 revB as per dwg verified by:EC
IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Date: 3/04/10

Required Date: 3/08/10

Start Qty: 4.002

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3696-041		Manufactured	No			100	Each	0.0000	4.0000			
Arm Assembly												
D3781-041		Manufactured	No			100	Each	5.0000	4.0000			
Lateral Cushion Assembly												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	5	
47992	1	
55171	4	

D3781-043		Manufactured	No			100	Each	1.0000	4.0000			
Armrest Cushion Assembly												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1	
48436	1	

D3785-3		Manufactured	No			100	Each	6.0000	4.0000			
Bracket												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST88	6	
54826	6	

1/3/11 @

54826

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 4, 2010 10:08:13 AM

Page 2

Work Order ID: 56666



Parent Item: D3780-041



Parent Item Name: Armrest Assembly

Start Date: 3/04/10

Required Date: 3/08/10

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
 IPP Rev:B 08-07-22 revB as per dwg verified by:EC
 IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Qty: 4.00 2

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3977-1		Manufactured	No			100	Each	19.0000	4.0000 <u>2</u>			
Bolt												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	19	
55180	19	

D3978-1



Nut

Manufactured	No					100	Each	19.0000	4.0000 <u>2</u>			

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST139	19	
55182	19	

D3979-1



Washer

Manufactured	No					100	Each	40.0000	<u>2</u> 4.0000			

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	4	
51703	4	
Main Warehouse		
ST105	36	
55183	36	

March 4, 2010 10:08:13 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 4, 2010 10:08:13 AM

Page 3

Work Order ID: 56666

Parent Item: D3780-041

Parent Item Name: Armrest Assembly



Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
 IPP Rev:B 08-07-22 revB as per dwg verified by:EC
 IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Date: 3/04/10

Required Date: 3/08/10

Start Qty: 4.00 *2*

Required Qty: 4.00

Component Item ID/ AN960JD10L	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of Each	Qty on 3,183.000	Remaining 8.0000 <i>4</i>	Qty	Date	Status
											<i>h</i>	

Washer

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
ST		3183	
101291		16	
105793		49	
110985		3118	

AN970-6

Purchased

No

100

Each

35.0000

8.0000

Washer

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
ST		35	
10538		8	
109798		27	

110988

109798

h 14/3/11

March 4, 2010 10:08:13 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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March 4, 2010 10:08:13 AM

Page 4

Work Order ID: 56666

Parent Item: D3780-041

Parent Item Name: Armrest Assembly

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
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 IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Date: 3/04/10

Required Date: 3/08/10

Start Qty: 4.00 2

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L3		Purchased	No			100	Each	2,383.000	8.0000			
Nut												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2377	
110844	35	
111274	27	
111668	52	
112314	285	
112385	260	
113523	18	
113537	700	
113644	1000	

112385

MS24665-302

Purchased

No



Cotter Pin

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	106	
111359	6	
113644	100	

1113644

14/3/10 2

March 4, 2010 10:08:13 AM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 4, 2010 10:08:14 AM

Page 5

Work Order ID: 56666

Parent Item: D3780-041

Parent Item Name: Armrest Assembly



Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
 IPP Rev:B 08-07-22 revB as per dwg verified by:EC
 IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Date: 3/04/10

Required Date: 3/08/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS24693-C272		Purchased	No			100	Each	1,392.000	8.0000	4		
												

Screw

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1392	
17137	519	
17831	520	
8814	3	
8815	31	
9063	19	
9370	300	

MS24693-C277

Purchased

No

100

Each

62.0000

8.0000

4

Screw

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	62	
109297	12	
113644	50	

9063

109297

March 4, 2010 10:08:14 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 4, 2010 10:08:15 AM

Page 6

Work Order ID: 56666



Parent Item: D3780-041



Parent Item Name: Armrest Assembly

Start Date: 3/04/10

Required Date: 3/08/10

Comments: IPP Rev:A 08-05-26 new issue DD verified by:ec
 IPP Rev:B 08-07-22 revB as per dwg verified by:EC
 IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

Start Qty: ~~4.00~~ 2

Required Qty: 4.00

Component Item ID/ NAS1149D0663J	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of Each	Qty on 493.0000	Remaining 4.0000 2	Qty	Date	Status
-------------------------------------	-------------	-------------------	-----------	---------	------	--------------	-----------------	--------------------	----------------------------------	-----	------	--------



Washer



Handwritten signature
 14/3/11 (2)

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	493	
112612	193	
113524	300	

112612

March 4, 2010 10:08:15 AM

Shop Packet Print

Page 6

8

7

6

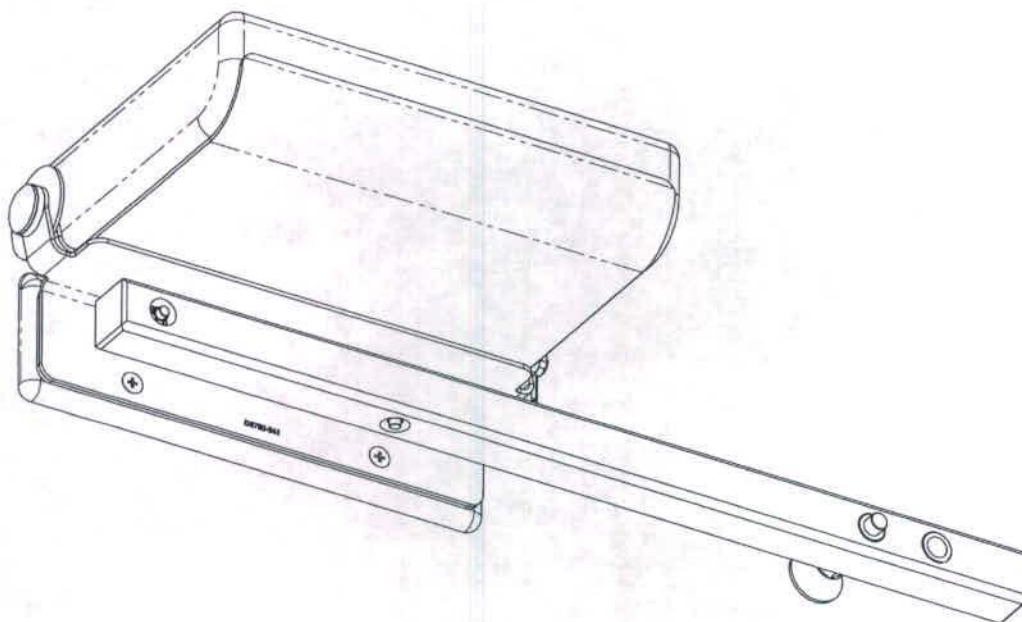
5

4

3

2

1



D3780-041 ARMREST ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	LATERAL CUSHION ASSEMBLY
5	1	D3781-043	ARMREST CUSHION BASE ASSY
6	1	D3785-3	BRACKET
7	1	D3977-1	BOLT (CARRIAGE), UNC
8	1	D3978-1	NUT (CASTELLATED), UNC
9	1	D3979-1	WASHER (SQUARE HOLE)
12	2	AN960JD10L	WASHER
13	2	AN970-6	WASHER
14	2	MS21042L3	NUT
15	1	MS24665-302	COTTER PIN
16	2	MS24693-C272	SCREW
17	2	MS24693-C277	SCREW
18	1	NAS1149D0663J	WASHER

*W/S
Saddle*

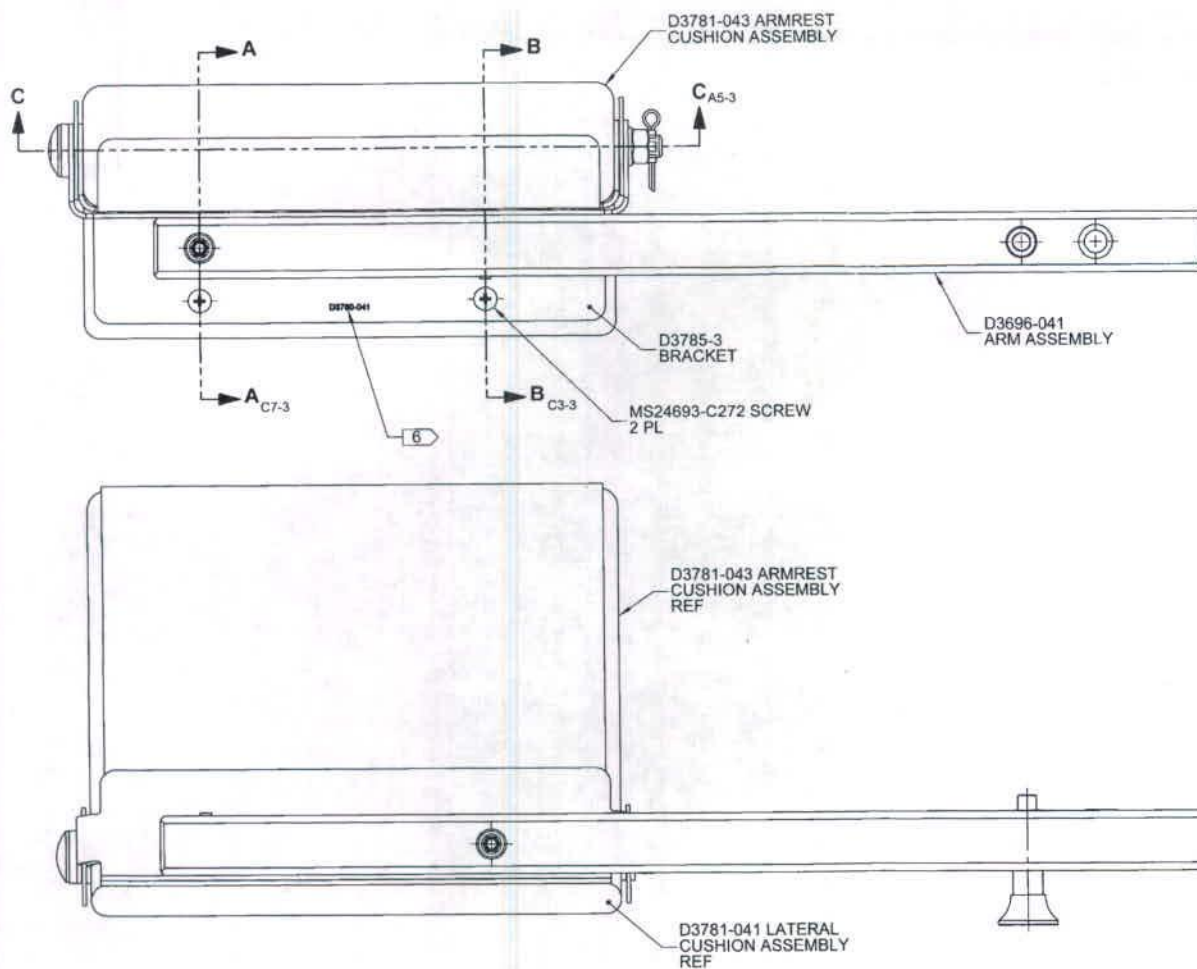
RELEASED
09/07/11

D	REDESIGNED BASED FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.11
C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA


DRAWING NO. **D3780** REV. D
SHEET 1 OF 3
TITLE **ARMREST ASSEMBLY** SCALE **NTS**

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D3780-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3780-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 3.71 lbs
- 8) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540 OR AC43.13 CHAPTER 7-127

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	09.05.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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RELEASED
01/04/11

